



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

646.3511
Job Sheet 170463



Part No: 646.3511

Job Qty: 10 ea
13

Part Name: Strut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 2/8/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV N/C 3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		2/7/18	0.00	0.00	Start Up Waterjet		DC 18/01/27
110	Waterjet	10 pcs		2/7/18	0.00	0.40	Waterjet1		DC 18/01/27
120	QC	10 pcs		2/7/18	0.00	0.00	QC2 Waterjet-1		DC 18/01/27
130	QC	10 pcs		2/7/18	0.00	0.00	QC8-1		DC 18/01/27
140	Small Fab	10 pcs		2/7/18	0.00	4.20	Small Fab-1		DC 18/02/01
150	QC	10 pcs		2/7/18	0.00	0.00	QC5		DC 18/02/01
160	Large Fab	10 pcs		2/7/18	0.00	11.49	Large Fab 1		DC 18/02/06
170	QC	10 pcs		2/7/18	0.00	0.00	QC9		PD 18-02-22
180	QC	10 pcs		2/7/18	0.00	0.00	QC5		PD 18-02-12
220	SprayPaint	10 pcs		2/8/18	0.00	0.46	Spray Paint		AB FEB 24 2018
230	QC	10 pcs		2/8/18	0.00	0.00	QC14		38
240	Packaging	10 pcs		2/8/18	0.00	0.00	Packaging3-1		CC 10/01/2018
250	QC21-SA	10 Ea		2/8/18	0.00	0.00	QC21		DC 18/03/01

Part Op 110 - 1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg

Descriptions: 140 - 1- Fabricate tube as per dwg USE DT10290 PUNCH

160 - Weld tube to plate as per dwg. DT9867

220 - Prime as per dwg (see note 3) 138802

240 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

DAG
21
9-88

MAR 05 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S16GA	0	127	0	0
140-Small Fab	M304TR0.500W.049	8	129	0	0

503742 7.79

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	2.750Inches ± 0.030	2.780 2.720		
2	Strut	1.500Inches ± 0.030	1.530 1.470		
3	Strut	0.063Inches ± 0.010	0.073 0.053		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work O Par NC Date :		Master Unit 000354 Job No 170463		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross-tube ☐ Water et ☐ Engineering ☐ Machining ☐ Cr. ☐ Quality ☐ Thermofinishing ☐ Finishing ☐ g ☐ Other ☐ Composite ☐ Supplier ☐	
		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval 	
Envirc Dc Equip/ Handli N Internal Tr: Tribal Kno		Te Se BC Br Ins Cor Col Cut Inst Drill		Start up Operation 01/27/18 Job No: 170463 Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence	
Substation Past Expiry Date Misidentified		Process Improvement Manufacturing Process Past Due		wave/twist in tube Marks/Chatter OTHER :	